



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D206-642-541
Job Sheet 200932



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3274-041 REV G IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/18/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		TF
							Skidtubes - 6		BE
							Skidtubes - 7		
114	QC 5	1 pcs	10/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		DAS
							QC 5 - 9		SEP 24 2019 68
116	QC 10	1 pcs	10/18/19		0.00	0.00	QC 5 - 30		9-89
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		



Dart Aerospace Ltd.
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CANADA
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Container No: S216466



Part: D206-642-541

Job No: 200932

Serial No/Batch: S216466

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, TC STC SH98-

Plex 9/19/19 10:50 AM Dart.lajeunesse.marie

120	Handfinish - 1-1 Chemical-B4B	1	pcs	10/18/19	0.00 0.68	QC 10 - 50	CZ
						QC 10 - 58	
						QC 10 - 9	
						Handfinish - 1 - 1 - B4B	BEB 19-10-02
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	A OCT 3 1 2019
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
130	QC 7	1	pcs	10/18/19	0.00 0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	

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					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Skidtubes - 4 - B4B	1 pcs	10/18/19	0.00 2.75	3:44h TF	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
200 QC 5	1 pcs	10/18/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
210 QC 10	1 pcs	10/18/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
220 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.45		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	10/18/19	0.00 0.40		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
240 QC 14	1 pcs	10/18/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	

DAS
68
9-89

OCT 31 2019

DAS
68
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OCT 31 2019

OCT 31 2019

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41 NOV 02 2019
9-89

19-11-04

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15
9-89

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
244 Handfinish - 3-1- WingWalk-B4B	1 pcs	10/18/19	0.00	0.50	Handfinish - 3 - 1 - B4B	JL 19-11-04
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	10/18/19	0.00	0.00	QC 3 - 10	BK 19-11-04
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	10/18/19	0.00	0.45	Handfinish - 4 - 1 - B4B	JL 19-11-04
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 -	

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260 QC 5	1 pcs	10/18/19	0.00 0.00	B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	10/18/19	0.00 0.68	QC 5 - 40	DAS NOV 04 2019 10 9-89
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 4 - 1 - B4B	19-10-04
280 QC 5	1 pcs	10/18/19	0.00 0.00	Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	

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					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
290	Packaging 3-1 - Stock - B4B	1 pcs	10/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
295	DC - 1 - B4B	1 pcs	10/18/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	NOV 0 6 2019
300	QC 21 - FG	1 pcs	10/18/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	NOV 0 6 2019
					QC 21 - FG - 53	

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per
 Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod
 Batch: 138989 / 139011 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274
 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig
 DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of

skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)

116 - (QC10- Inspect visual per QSI004- ground welds)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200 - (QC5- Inspect part completeness to step on W/O)

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125

240 - (QC14- Inspect Spray Paint)

244 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

246 - (QC3- Inspect Part Finish)

250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts

270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

280 - (QC5- Inspect part completeness to step on W/O)

290 - (Identify as per dwg & Stock Location: _____) Location : FG073

295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005

300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

212762

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5189763
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5043388
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5219835
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5225982
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5199330
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5049573
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5163280-3
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5218686
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5225311
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057496
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5160607
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	52070761
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5207779
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218182
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164002
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5200286
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5210726
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5204982
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201002
NAS1149C0332R	Washer (AN960C10L)	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	52181521
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104377

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9/19/2010

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	5	0
	D3285-1	1	7	0
150-Skidtubes - 2 - B4B	D3282-041	1	3	0
190-Skidtubes - 4 - B4B	D2649	12	83	0
	D3275-1	12	196	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	5,946	0
	CCR264SS3-3	2	55	0
	CR3212-4-03	2	38	0
	D3415-041	1	1	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	584	0
	AN4C5A	1	70	0
	D2646	1	58	0
	D3413-1	1	19	0
	D3537-1	9	144	0
	D3537-3	1	10	0
	D3672-1	2	1,439	0
	D4956-15	1	7	0
	D4956-23	1	16	0
	D4956-35	1	21	0
	D4956-39	1	9	0
	NAS1149C0332R	80	2,920	0
	NAS1149C0463R	1	205	0
Part Specifications				
Specifications could not be found.				

Plex 9/19/19 10:50 AM Dart.lajeunesse.marie

Qty	Qty	Part Number	Description
1	1	D5274-441	SKIDTUBE ASSEMBLY
1	1	D5274-443	SKIDTUBE ASSEMBLY
1	1	D5274-446	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D5274-449	EXTENSION
1	1	D5274-450	ART CAP
1	1	D5274-451	CROSS BOLT SPACER
1	1	D5274-452	CROSS BOLT SPACER
1	1	D5274-453	FLOAT WEB
1	1	D5274-454	CAP
1	1	D5274-455	RING
1	1	D5274-456	NUT PLATE
1	1	D5274-457	WEARPAD
1	1	D5274-458	WEARPAD
1	1	D5274-459	WEARPAD
1	1	D5274-460	WEARPAD
1	1	D5274-461	WEARPAD
1	1	D5274-462	WEARPAD
1	1	D5274-463	WEARPAD
1	1	D5274-464	WEARPAD
1	1	D5274-465	WEARPAD
1	1	D5274-466	WEARPAD
1	1	D5274-467	WEARPAD
1	1	D5274-468	WEARPAD
1	1	D5274-469	WEARPAD
1	1	D5274-470	WEARPAD
1	1	D5274-471	WEARPAD
1	1	D5274-472	WEARPAD
1	1	D5274-473	WEARPAD
1	1	D5274-474	WEARPAD
1	1	D5274-475	WEARPAD
1	1	D5274-476	WEARPAD
1	1	D5274-477	WEARPAD
1	1	D5274-478	WEARPAD
1	1	D5274-479	WEARPAD
1	1	D5274-480	WEARPAD
1	1	D5274-481	WEARPAD
1	1	D5274-482	WEARPAD
1	1	D5274-483	WEARPAD
1	1	D5274-484	WEARPAD
1	1	D5274-485	WEARPAD
1	1	D5274-486	WEARPAD
1	1	D5274-487	WEARPAD
1	1	D5274-488	WEARPAD
1	1	D5274-489	WEARPAD
1	1	D5274-490	WEARPAD
1	1	D5274-491	WEARPAD
1	1	D5274-492	WEARPAD
1	1	D5274-493	WEARPAD
1	1	D5274-494	WEARPAD
1	1	D5274-495	WEARPAD
1	1	D5274-496	WEARPAD
1	1	D5274-497	WEARPAD
1	1	D5274-498	WEARPAD
1	1	D5274-499	WEARPAD
1	1	D5274-500	WEARPAD

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: N/A
3. CHEMICAL CONVERSION COAT PER DART CSI 005 4.1 PRIOR TO INSTALLING D5282-041 WEB PRIME (REF 4.2, 4.3) OUTSIDE ONLY AND PAINT WHITE PER DART CSI 005 4.2 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART CSI 005 4.4
4. CHEMICAL CONVERSION COAT PER DART CSI 005 4.1 PRIOR TO INSTALLING D5282-041 WEB PRIME (REF 4.2, 4.3) INSIDE AND OUTSIDE PER DART CSI 005 4.2.1
5. PAINT BLACK PER DART CSI 005 4.2.2 USING CABOT'S 57033 CAMOFLAG BLACK PER MIL-PPF-06288E TYPE I CLASS H
6. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART CSI 005 4.4
7. TOLERANCES ARE PER DART CSI 013 UNLESS OTHERWISE NOTED.
8. UNITS: INCHES UNLESS OTHERWISE NOTED
9. BREAK SHARP EDGES 0.005 TO 0.010 MAX
10. IDENTIFY PARTS BY PART NUMBER AND DATE OF MANUFACTURE
11. WEIGHT: FOR 24" X 14" X 37.5 LBS
12. FOR 24" X 14" X 37.5 LBS
13. ALL HOLES DRILLED ON CENTER LINES
14. DAMAGED TOLERANCE ON CENTER LINES
15. THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.100" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
16. ADHERIVE PER DART CSI 013. ENSURE HOLES LINE-UP.
17. DRILL 20.25" HOLES FOR AL37-1032-150 INSERTS USING D5274-472 BEFORE FINISH. INSTALL AL37-1032-150 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SEALFLEX-3417-291. ON -045, DO NOT DRILL HOLES ON INSTALL. FASTENERS WITH 100 LBS TORQUE. FASTENERS 100 LBS TORQUE AFTER FINAL ASSEMBLY.
18. CLEAN EXCESS GREASE WITH WASH 14 WIDE DEGREASER.
19. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

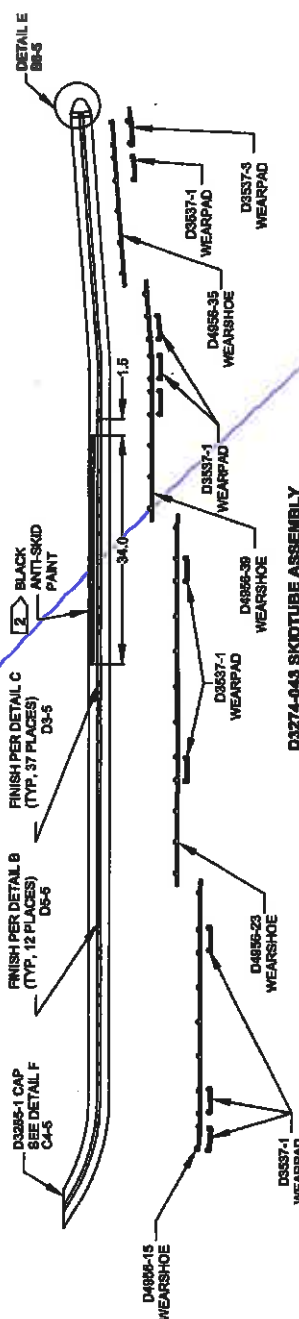
RELEASED
R 2016-07-26
ECU 11-16

REV.	DESIGN	CP	RF	AK	JLM	DS	DATE
G	ADD -045 CONFIGURATION (FOR PH)	2N AS-4, AS-5	DS	18.04.25			
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-D206-942 REV Q	DS	14.04.15				
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PART 13-255	DW	13.05.17				
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19				
C	ADD -045; NEW INSERTS	CP	05.03.18				
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.06.09				
A	NEW ISSUE	CP	04.03.15				
REV.	DESCRIPTION	CP	RF	AK	JLM	DS	DATE
	DART AEROSPACE USA, INC						
	EUGENE, OR						
	DRAWING NO. D3274						
	TITLE SKIDTUBE ASSEMBLY						
	DATE 16.04.25						
	SCALE 1 OF 6						
	NTS						

UNCONTROLLED
200932 MJS
19-09-19

D3274-043 DRILLING/ASSEMBLY DETAIL

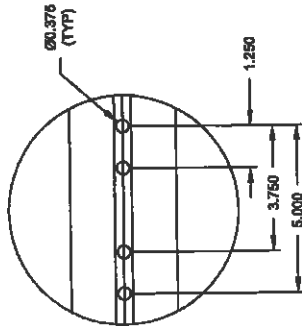
D3274-043 BEND/DRILLING DETAIL



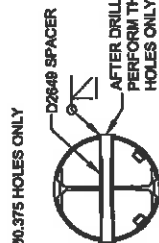
D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

DESIGN	CP	DART AEROSPACE USA, INC EUGENE, OR REV. G SHEET 3 OF 6 SCALE NTS
DRAWN	RF	
CHECKED	AK	
MFG. APPR.	JLM	
APPROVED	DS	
DE APPR.		TITLE SKIDTUBE ASSEMBLY
DATE		16.04.25 COPY MADE BY DART AEROSPACE USA, INC THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED FOR THE PROJECT AND NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.

DETAIL A: DRILL DETAIL
D4-2, D5-2, D6-3, D8-3

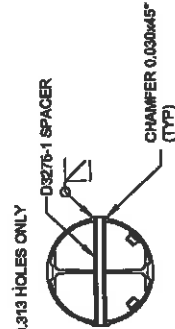


DETAIL B
B4-2, B4-3



FOR Ø0.375 HOLES ONLY

DETAIL C
B4-2, B4-3

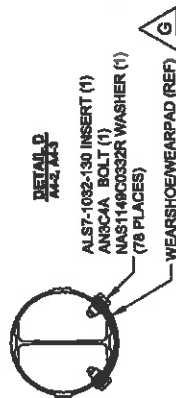


FOR Ø0.313 HOLES ONLY

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:

1. CHAMFER HOLE 0.030x45°
2. INSERT D2648 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313x0.75 DEEP

DETAIL D
A4-2, A4-3



- AL57-1032-130 INSERT (1)
- AN304A BOLT (1)
- NAS1149C0332R WASHER (1)
- (78 PLACES)

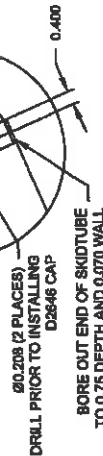
WEARSHOE/WEARPAD (REF)

DETAIL E
B4-2, B4-3



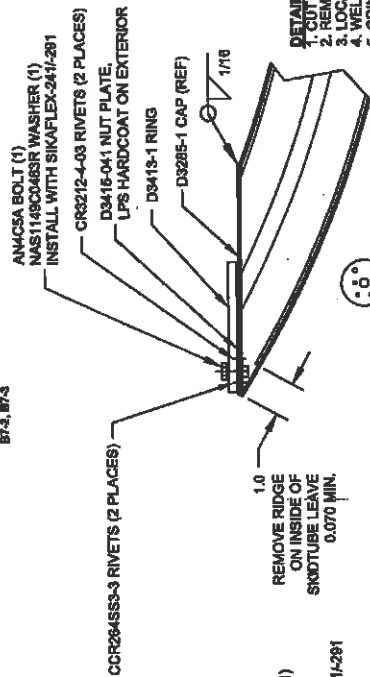
- AN304A BOLT (1)
- NAS1149C0332R WASHER (1)
- D3872-1 WASHER (1)
- (2 PLACES)
- INSTALL WITH SIKAFLEX-241-281

SEAL WITH
SIKAFLEX-241/281
ADHESIVE



- Ø0.208 (2 PLACES)
- DRILL PRIOR TO INSTALLING
D2648 CAP
- BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL
B7-2, B7-3



- AN405A BOLT (1)
- NAS1149C0468R WASHER (1)
- INSTALL WITH SIKAFLEX-241-281
- CR3212-4-03 RIVETS (2 PLACES)
- D3416-041 NUT PLATE,
- LPS HARDCOAT ON EXTERIOR
- D3413-1 RING
- D3285-1 CAP (REF)
- 1/16

REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3413-041

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART C81 004
 5. GRIND FLUSH
 6. RIVET D3413-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3413-041
PRIOR TO FINISH

DART AEROSPACE USA, INC
EUGENE, OR

DESIGN	CP	RF	AK	JLM	D8	DATE	16.04.25
DRAWN							
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.							
TITLE	SKIDTUBE ASSEMBLY						
SCALE	NTS						
REV. G	SHEET 5 OF 8						

RELEASED
R 2016-07-26

-041-043 DETAILS

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PAGE 1 OF 1

Description: REPLACEMENT FLOAT SKIDTUBE, LH/RH

H:\Forms\Engineer\Approved Eng Online\CHGREC revB